

Date: Tuesday, 07/04/2009 3:22:29 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STABILIZER ARM
Job Number	: 47059		
Estimate Number	: 13523		
P.O. Number	:	Part Number	: PB674300157
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: B6743001 P.13
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 07/04/2009 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 45025	Material	:
Written By	: _____	Due Date	: 14/04/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>mf 09-04-08.</u>		
Comment	: Est Rev:A 08-07-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001111	Tube End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube End Plate

batch:

2.0 PB6743001107 Tube Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube Arm

batch:

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg PB67-43001

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

6.0	PB6743001109	Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Male Eye

batch:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STABILIZER ARM

Job Number: 47059

Part Number: PB674300157

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SPRING SLOTTED PIN

batch: *M 111000-2A*

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -107 and -109 using existing pilot hole of -107 as per dwg

2- install spring pin

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: *2:20pm*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *2:50pm*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Pkg Blade fold*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C2 09/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

